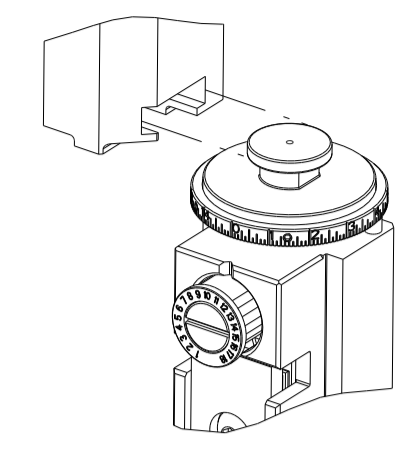


PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2151184-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2151184-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
5-2151184-1	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	MECHANICAL
5-2151184-2	J	SEAL STRIPPER CRIMPER TERMINATING UNIT	PNEUMATIC
7-2151184-1	J	MECHANICAL AND CRIMP TOOLING KIT	MECHANICAL
7-2151184-2	J	PNEUMATIC AND CRIMP TOOLING KIT	PNEUMATIC
7-2151184-7	G	CRIMP TOOLING KIT	-

ATLANTIC VERSION TERMINATOR INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.78 mm [.070]	BX

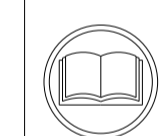
APPLICATOR INSTRUCTIONS 408-35042

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES REC / TAB CONTACT			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.50 mm [.157-.177 IN]		Ø1.80-2.00 mm [.071-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5094 (B)114-5108 (C)114-5111 (D)114-13170		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 173681-1	(A) 173681-2	(A) 173681-3	(A) 173681-4
(A) 173681-6	(B) 173682-1	(B) 2098032-1	(C) 2098032-3
(C) 173716-1	(C) 173716-2	(D) 776768-2	(D) 776768-3
(A) 2297066-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES TSAB CONTACT MULTI-LOC			
WIRE STRIP LENGTH		INSULATION DIAMETER RANGE	
4.00-4.50 mm [.157-.177 IN]		Ø1.40-2.00 mm [.055-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5094		
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 776181-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	1.02+/-0.05 [.040+/- .002]	4.8
0.30mm ²	0.92+/-0.05 [.036+/- .002]	5.8
20 AWG OR 0.50mm ²	0.97+/-0.05 [.038+/- .002]	5.3
22 AWG OR 0.30mm ²	0.88+/-0.05 [.035+/- .002]	6.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.17+/-0.05 [.046+/- .002]	3.3



- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINALS 173716, 173681, 173682, AND 2098032 CRIMP WIRE SIZES OF 0.30mm² (7/0, 26) AND 0.50mm² (7/0, 32); TYPICALLY AVS. REFER TO APPLICABLE TERMINAL APPLICATION SPECIFICATION FOR CALCULATED CROSS-SECTIONAL AREA.
- ADJUSTMENTS ARE REQUIRED WHEN CHANGING TERMINALS.
- TERMINAL LUBRICANT IS RECOMMENDED.

***WARNING**
ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMPTOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		H		ECR-19-009777	06JUL2019	TB	TE
		H1		ECR-20-009123	25JUN2020	JWC	TE
		H2		ECR-21-006034	04JUN2021	LJ	YY
		J		ECR-22-141812	08JUN2022	JWC	TE

-	-	-	1	1	-	-	1803515-3	RAM ASSEMBLY, SF ATLANTIC	293
-	-	-	1	1	-	-	2-1803583-1	APPLICATOR BASIC ASSEMBLY, SF	292
-	1	-	1	-	1	-	2119641-1	FEED CAM, AIR FEED	248
-	1	1	1	1	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	1	1	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
3	-	1	1	1	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	1	1	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	-	1	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	1	-	1	-	2844940-1	AIR FEED MODULE	238
-	-	-	1	1	-	-	4-1722335-3	STRIPPER, SIDE FEED	182
-	-	-	1	1	-	-	1-5018030-0	NUT, HEX, REG, RoHS, M3.5	181
3	-	-	-	1	1	-	1-1752354-9	STANDOFF, HOLD-DOWN	180
-	-	-	1	1	-	-	993111-1	PIN, SLOTTED SPRING 3.0 X 20.0	177
-	-	-	1	1	-	-	5-22280-0	SPRING, COMPRESSION	176
-	-	-	1	1	-	-	1752353-3	GUIDE PIN, HOLDDOWN	175
-	-	-	1	1	-	-	1901680-2	GUIDE PIN, HOLDDOWN	174
-	REF	REF	REF	REF	REF	REF	994970-2	COUNTER, MAGNETIC	164
8	-	1	1	1	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	1	1	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	1	1	1	1	2844907-1	POST, LOCKING	98
-	1	1	1	1	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	1	1	1	1	2119791-8	DEPRESSOR, WIRE	73
-	1	1	1	1	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	1	1	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	1	1	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2	2	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	1	1	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	60
-	1	1	1	1	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1	1	1	1	1338685-1	PAWL, FEED	56
-	4	4	4	4	4	4	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	54
-	2	2	2	2	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	1	1	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	1	1	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	1	1	1	1	690753-2	SPACER, TONKER	50
-	1	2	1	2	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	-	1	-	1	2119652-1	FEED CAM, PRE FEED	48
-	-	1	-	1	-	1	2119653-1	FEED CAM, POST FEED	47
-	1	1	-	-	1	1	1803583-9	APPLICATOR BASIC ASSEMBLY, SF	46
-	1	1	-	-	1	1	1803515-1	RAM ASSEMBLY, SF ATLANTIC	44
-	1	1	1	1	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	1	1	1	1	2-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2	2	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	2	2	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	1	1	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1	1	1	1	1320928-2	STRIP GUIDE	24
-	1	1	-	-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1	1	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	-	-	1	1	2119533-1	STRIPPER, SIDE FEED	19
1	1	1	1	1	1	1	2119806-1	INSERT, SHEAR	13
1	1	1	1	1	1	1	3-22280-3	SPRING, COMPRESSION	12
1	1	1	1	1	1	1	1-356885-4	STOP, SHEAR	11
1	1	1	1	1	1	1	2119805-1	SHEAR HOLDER, FRONT	10
1	1	1	1	1	1	1	1803095-1	FLOATING SHEAR, FRONT	9
1	2	2	1	1	1	1	4-1333202-6	ANVIL, COMBINATION	8
-	1	1	1	1	1	1	3-240641-3	SPACER	7
-	-	-	-	-	-	-	-	-	6
-	1	1	1	1	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	1	1	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
1	2	2	1	1	1	1	1633988-5	CRIMPER, INSULATION BOX PREMIUM	3
-	1	1	1	1	1	1	455888-1	SPACER, CRIMPER	2
1	2	2	1	1	1	1	3-456403-4	CRIMPER, WIRE PREMIUM	1

ITEM NO	PART NO	DESCRIPTION
-77	-72	-71
-52	-51	-2
-1		

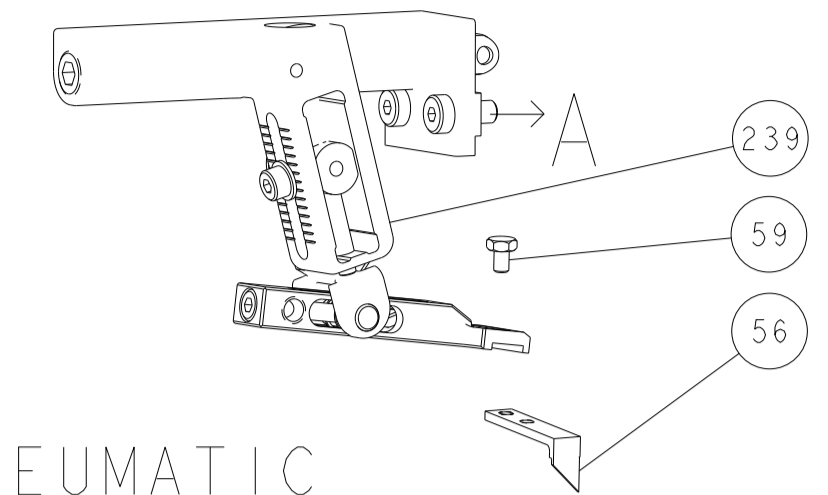
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CHK	S. XI	10AUG2011
APVD	J. CRUZ	01JUN2011
PRODUCT SPEC		
APPLICATION SPEC		
WEIGHT		
SCALE	1:2	SHEET 1 OF 4
REV	J	

Customer Accessible Production Drawing

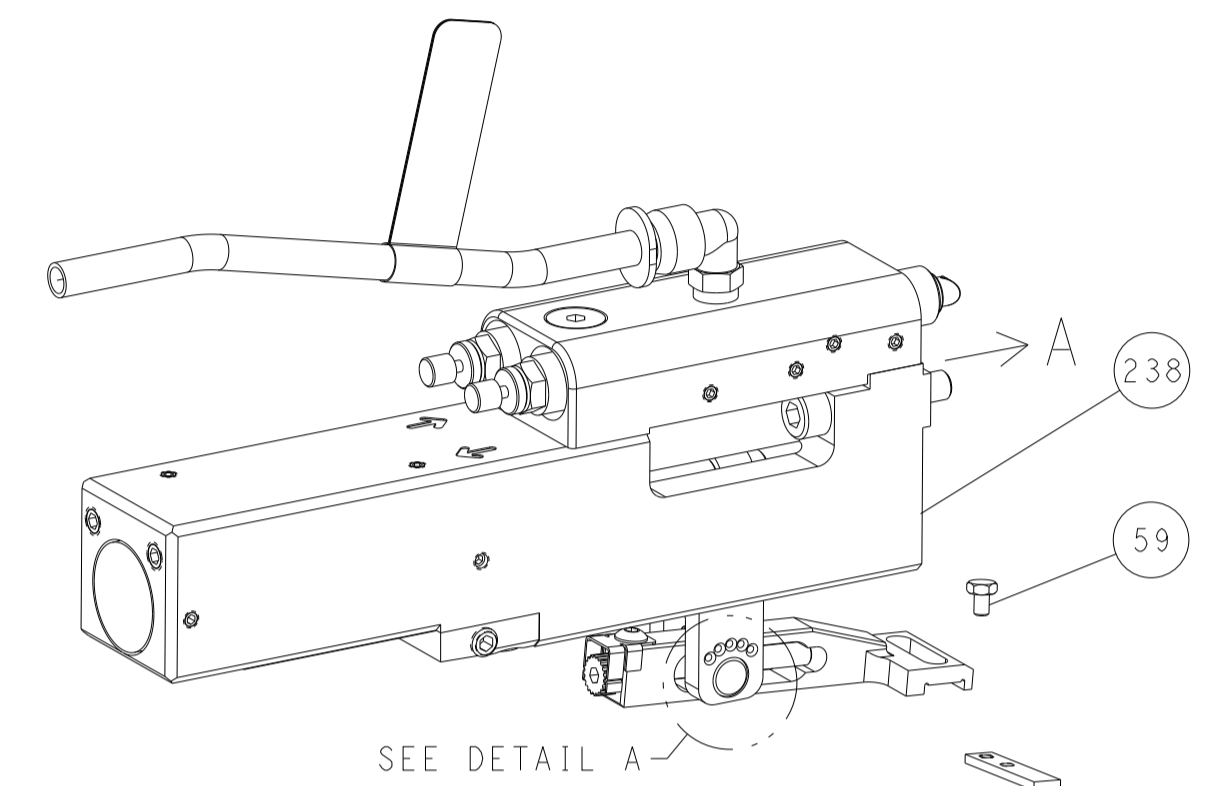
ATLANTIC VERSION
Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

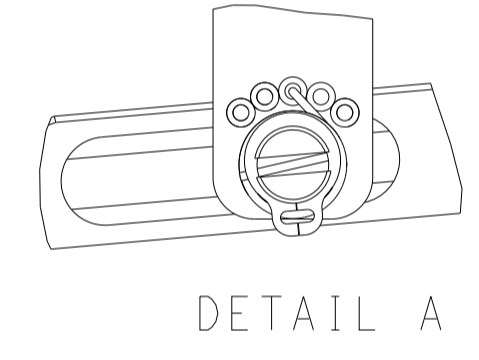
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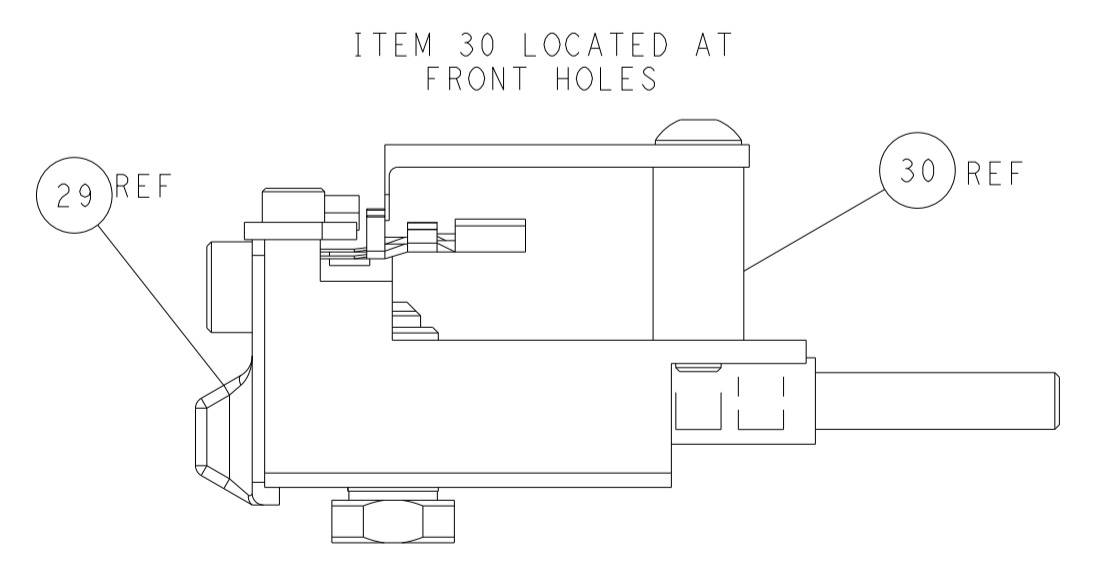
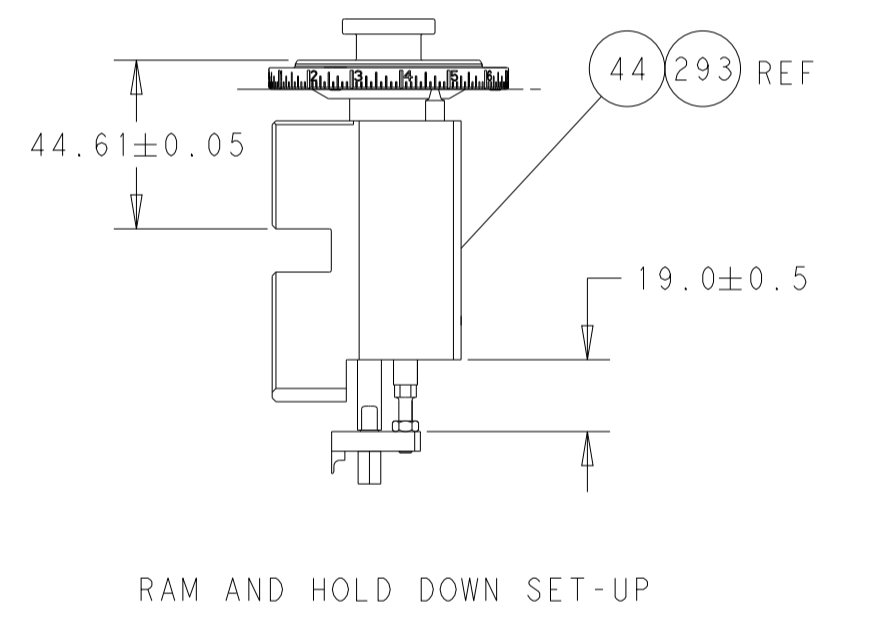
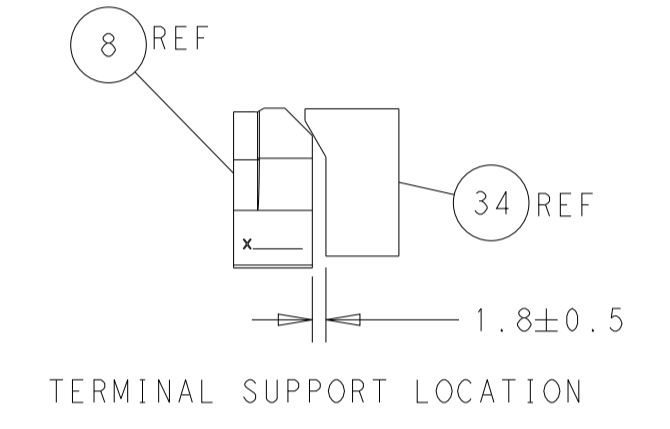
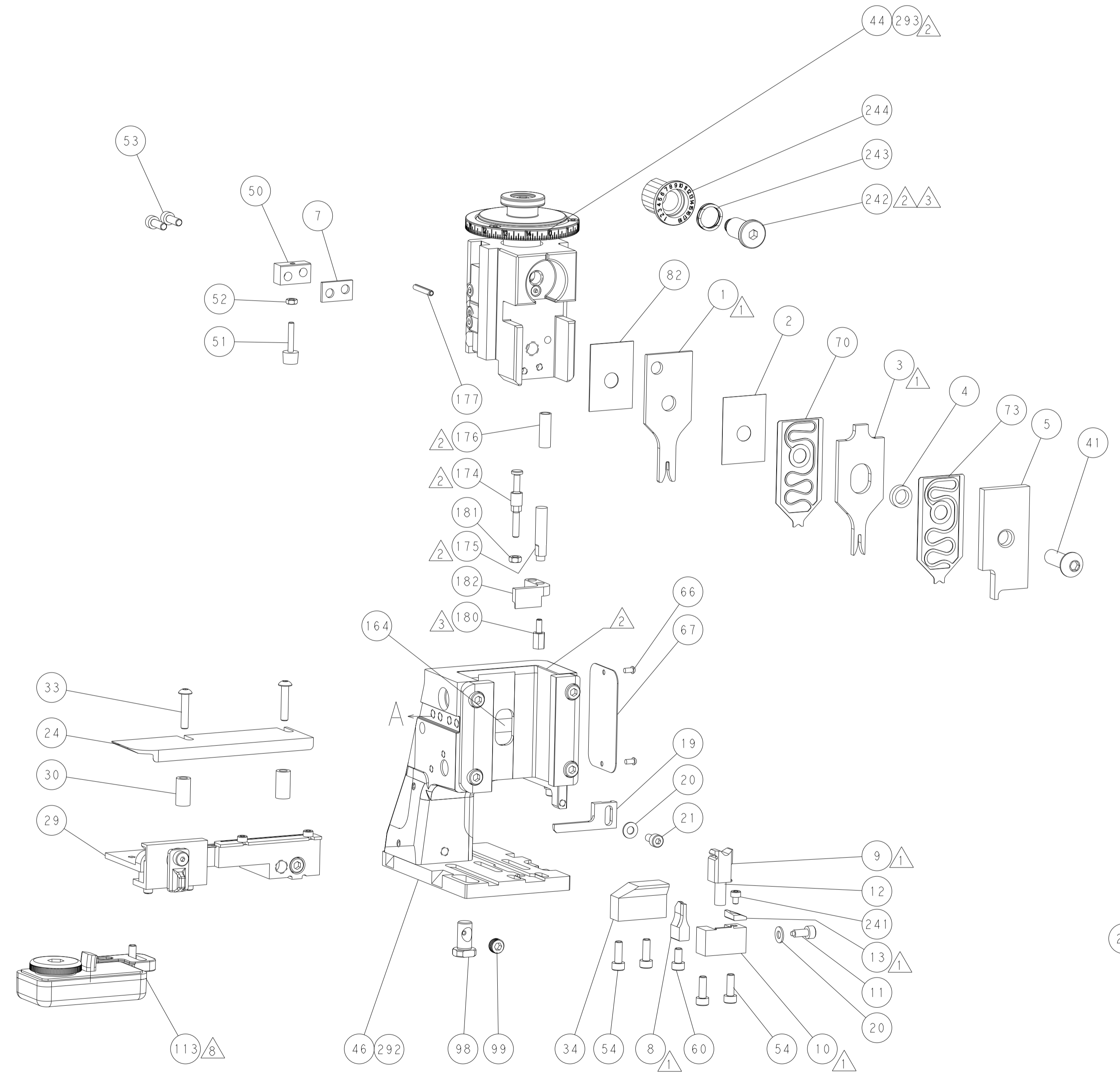
PNEUMATIC



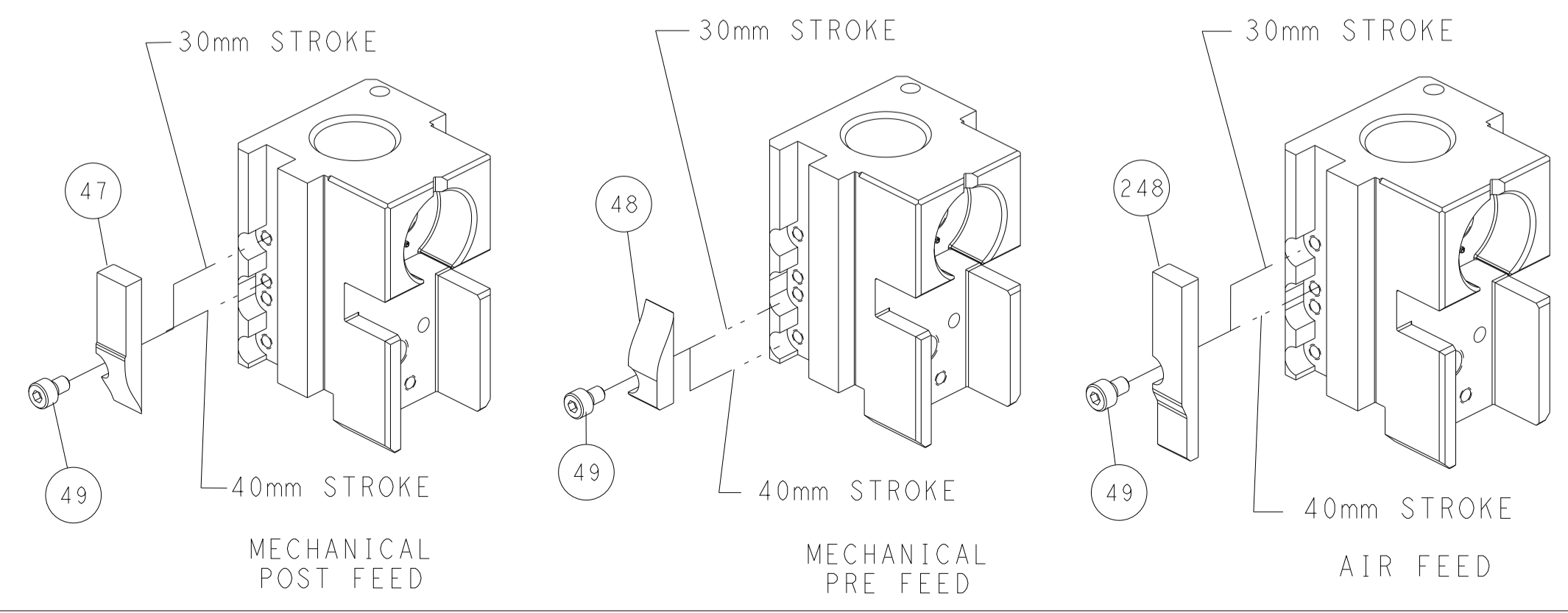
SEE DETAIL A
 FEED SPRING SETTING POSITION
 (SHOWN FROM REAR SIDE)



DETAIL A



CAM POSITIONS

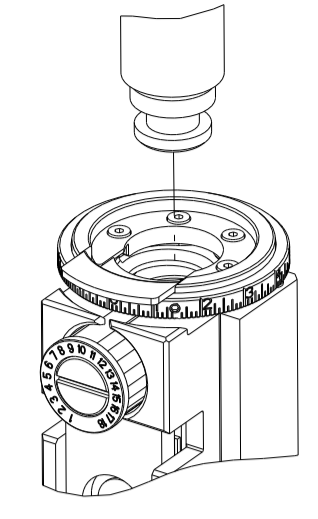


ATLANTIC VERSION
 Shown on sheets 1 of 4 & 2 of 4
 (Pacific version shown on sheets 3 of 4 & 4 of 4)

<small>THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION BY TYCO ELECTRONICS CORPORATION. ALL RIGHTS RESERVED.</small>		DWN X.ZHAO 10AUG2011 CHK S.XI 10AUG2011 APVD J.CRUIZ 01JUN2011	NAME Ocean Side Feed Applicator
DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 ©=2151184 SHEET 2 OF 4 REV J

PART NUMBER	REVISION	DESCRIPTION	FEED TYPE
2-2151184-1	J	FINE CRIMP HEIGHT ADJUST	MECHANICAL
2-2151184-2	J	FINE CRIMP HEIGHT ADJUST	PNEUMATIC
7-2151184-7	G	CRIMP TOOLING KIT	-

PACIFIC VERSION TERMINATOR
 INTERFACE ADAPTER



APPLICATOR DATA		
CRIMP	SIZE	TYPE
WIRE	1.57 mm [.062]	F
INSUL	1.78 mm [.070]	BX
APPLICATOR INSTRUCTIONS 408-35042		

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES REC / TAB CONTACT			
WIRE STRIP LENGTH 4.00-4.50 mm [1.57-.177 IN]		INSULATION DIAMETER RANGE Ø1.80-2.00 mm [.071-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5094 (C)114-5111	(B)114-5108 (D)114-13170	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 173681-1	(A) 173681-2	(A) 173681-3	(A) 173681-4
(A) 173681-6	(B) 173682-1	(B) 2098032-1	(C) 2098032-3
(C) 173716-1	(C) 173716-2	(D) 776768-2	(D) 776768-3
(A) 2297066-1			

TERMINAL DATA: TE TERMINAL		TE CRIMP SPECIFICATION	
TERMINAL NAME: .040 SERIES TSAB CONTACT MULTI-LOC			
WIRE STRIP LENGTH 4.00-4.50 mm [1.57-.177 IN]		INSULATION DIAMETER RANGE Ø1.40-2.00 mm [.055-.079 IN]	
TERMINAL APPLICATION SPECIFICATION	(A)114-5094	-	-
TERMINALS APPLIED			
TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 776181-1			

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
0.50mm ²	1.02 +/- 0.05 [1.040 +/- .002]	4.8
0.30mm ²	0.92 +/- 0.05 [1.036 +/- .002]	5.8
20 AWG OR 0.50mm ²	0.97 +/- 0.05 [1.038 +/- .002]	5.3
22 AWG OR 0.30mm ²	0.88 +/- 0.05 [1.035 +/- .002]	6.2

WIRE SIZE	CRIMP HEIGHT mm [INCH]	CRIMP HEIGHT REFERENCE SETTING
18 AWG	1.17 +/- 0.05 [1.046 +/- .002]	3.3

- RECOMMENDED SPARE PARTS
- REFER TO SUPPLIED INSTRUCTION SHEET FOR CLEANING, LUBRICATION AND STORAGE OF APPLICATOR.
- APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242. APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 180.
- CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.
- UNLESS SPECIFIED OTHERWISE TORQUE VALUES SHALL BE USED PER DOCUMENT, 101-35000.
- TERMINALS 173716, 173681, 173682, AND 2098032 CRIMP WIRE SIZES OF 0.30mm² (7/0.26) AND 0.50mm² (7/0.32); TYPICALLY AVS. REFER TO APPLICABLE TERMINAL APPLICATION SPECIFICATION FOR CALCULATED CROSS-SECTIONAL AREA.
- ADJUSTMENTS ARE REQUIRED WHEN CHANGING TERMINALS.
- TERMINAL LUBRICANT IS RECOMMENDED.

***WARNING**
 ON INSTALLATION, SET WIRE DISC TO CRIMP HEIGHT REFERENCE SETTING FOR LARGEST WIRE SIZE. CRIMP HEIGHT REFERENCE SETTINGS GREATER THAN THE VALUE SHOWN MAY CAUSE DAMAGE TO THE CRIMP TOOLING. REFER TO THE INSTRUCTION SHEET FOR PROPER SETUP AND ADJUSTMENTS.

ENTRY LEVEL APPLICATOR		ITEM SUBSTITUTION LIST		
PART NUMBER	SAME AS	ITEM	ITEM DESCRIPTION	SUBSTITUTE PART NUMBER
8-2151184-1	2151184-1	1	WIRE CRIMPER	3-1803547-4
8-2151184-2	2151184-2	3	INSULATION CRIMPER	1803622-5
9-2151184-1	2-2151184-1	46	BASIC SUB -ASSEMBLY	1803940-9
9-2151184-2	2-2151184-2	141	BASIC SUB -ASSEMBLY	1-1803940-0
			LUBRICATOR	DELETE

PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

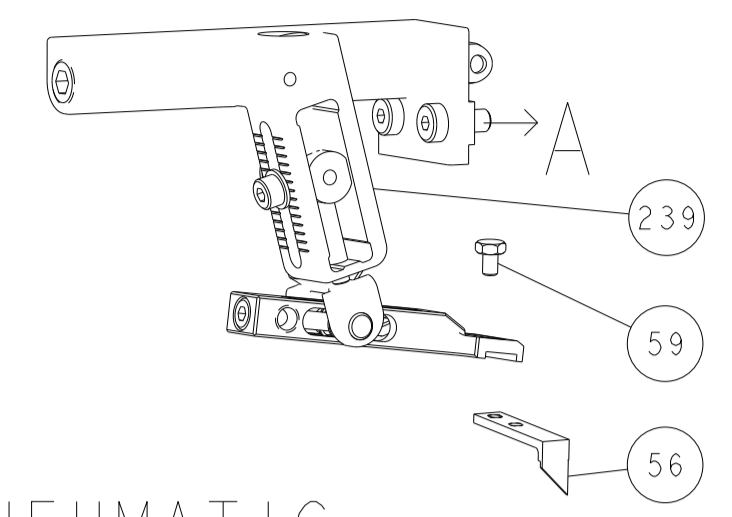
LOC	DIST	REVISIONS				
A	66	P LTM	DESCRIPTION	DATE	OWN	APVD
		-	SEE SHEET 1	-	-	-

-	1	1	2119082-6	CAM, SNAIL, INSULATION ADJUSTMENT	244
-	1	1	2079764-1	WASHER, WAVE SPRING, CREST-TO-CREST	243
-	1	1	2119083-1	RETAINER, INSULATION DIAL	242
-	1	1	7-18023-7	SCR, SKT HD CAP M3 X 4.0	241
-	-	1	2119580-1	MECHANICAL FEED ASSEMBLY	239
-	1	-	2844940-1	AIR FEED MODULE	238
-	REF	REF	994970-2	COUNTER, MAGNETIC	164
-	1	-	2119641-2	FEED CAM, AIR FEED	151
-	1	1	2168083-8	SCR, SKT HD CAP, RoHS, M4 X 16	144
-	4	4	2168083-9	SCR, SKT HD CAP, RoHS, M4 X 20	143
-	-	1	2119653-2	FEED CAM, POST FEED	142
-	1	1	1-1803583-0	APPLICATOR BASIC ASSEMBLY, SF	141
-	1	1	1803516-1	RAM ASSEMBLY, SF PACIFIC	140
-	1	1	2119955-1	ASSY, LUBRICATOR, SIDE FEED	113
-	1	1	2844908-1	SCREW, LOCKING	99
-	1	1	2844907-1	POST, LOCKING	98
-	1	1	455888-5	SPACER, CRIMPER	82
-	1	1	2119791-8	DEPRESSOR, WIRE	73
-	1	1	1803607-3	DOCUMENTATION PACKAGE	71
-	1	1	2119791-5	DEPRESSOR, WIRE	70
-	1	1	2119740-1	TAG, IDENTIFICATION	67
-	2	2	2168078-1	SCREW, DRIVE, RH, RoHS, 2 x .188	66
-	1	1	5-18022-5	SCR, HEX HD CAP, M4 X 6.0	59
-	1	1	1338685-1	PAWL, FEED	56
-	2	2	2168083-3	SCR, SKT HD CAP, RoHS, M4 X 12.0	53
-	1	1	5018030-1	NUT, HEX, REG, RoHS, M3	52
-	1	1	811242-5	BUMPER, HOLD DOWN	51
-	1	1	690753-2	SPACER, TONKER	50
-	1	2	18023-9	SCR, SKT HD CAP M4 X 6.0	49
-	-	1	2119652-1	FEED CAM, PRE FEED	48
-	1	1	1803602-1	SCR, BHSC, RoHS (M8 X 25)	41
-	1	1	2-1752356-3	SUPPORT, TERMINAL	34
-	2	2	2079383-5	SCR, BHSC, RoHS (M4 X 20)	33
-	2	2	3-2844962-0	SPACER, CYLINDRICAL, STRIP GUIDE	30
-	1	1	2844992-1	ASSEMBLY, STRIP GUIDE	29
-	1	1	1320928-2	STRIP GUIDE	24
-	1	1	2168083-2	SCR, SKT HD CAP, RoHS, M4 X 8.0	21
-	2	2	1-18028-2	WASHER, FLAT, REG M4	20
-	1	1	2119533-1	STRIPPER, SIDE FEED	19
-	1	1	2119806-1	INSERT, SHEAR	13
-	1	1	3-22280-3	SPRING, COMPRESSION	12
-	1	1	1-356885-4	STOP, SHEAR	11
-	1	1	2119805-1	SHEAR HOLDER, FRONT	10
-	1	1	1803095-1	FLOATING SHEAR, FRONT	9
-	1	1	4-1333202-6	ANVIL, COMBINATION	8
-	1	1	3-240641-3	SPACER	7
-	-	-	-	-	6
-	1	1	2119757-8	DEPRESSOR, SHEAR	5
-	1	1	2-238011-1	BLOCK, CRIMPER SPACER	4
-	1	1	1633988-5	CRIMPER, INSULATION BOX PREMIUM	3
-	1	1	455888-1	SPACER, CRIMPER	2
-	1	1	3-456403-4	CRIMPER, WIRE PREMIUM	1

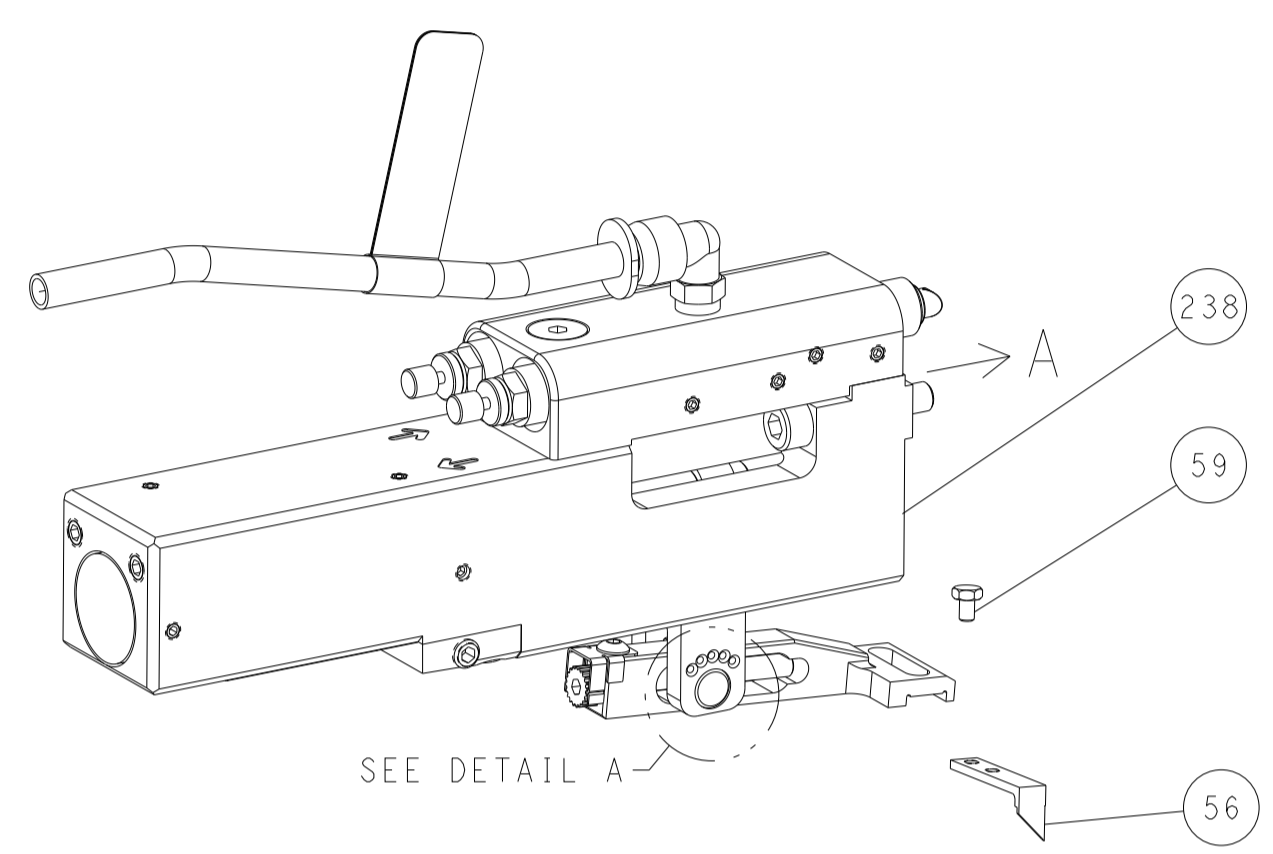
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0 PLC ±		1 PLC ±		2 PLC ±		3 PLC ±		4 PLC ±		RESTRICTED TO	
MATERIAL:		FINISH:		WEIGHT:		SCALE: 1:2		SHEET 3 OF 4		REV J	

LOC	DIST	REVISIONS					
A	66	P	LTN	DESCRIPTION	DATE	OWN	APVD
		-		SEE SHEET 1			

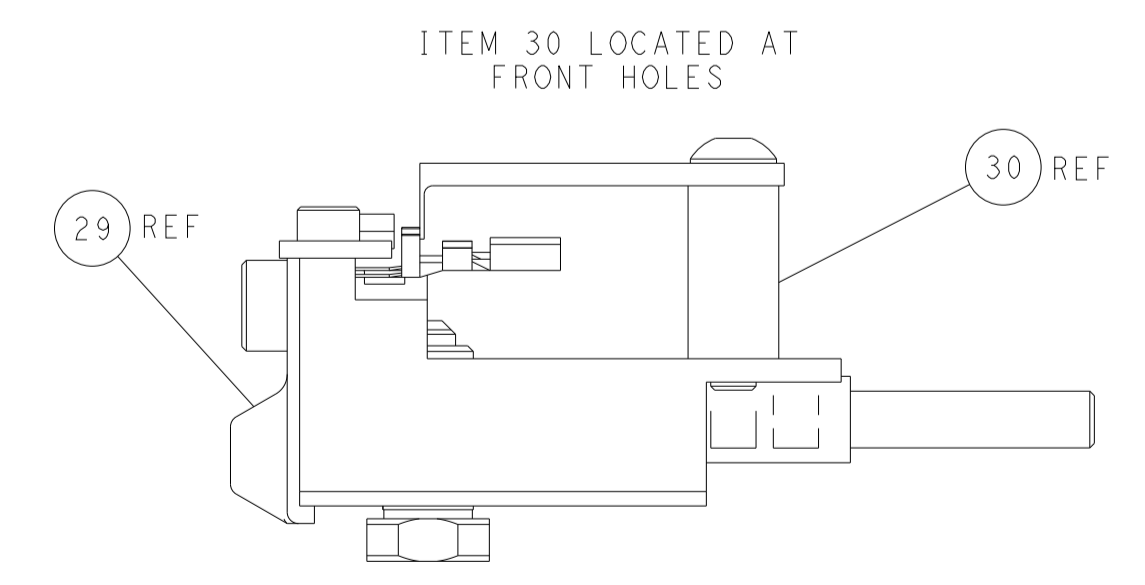
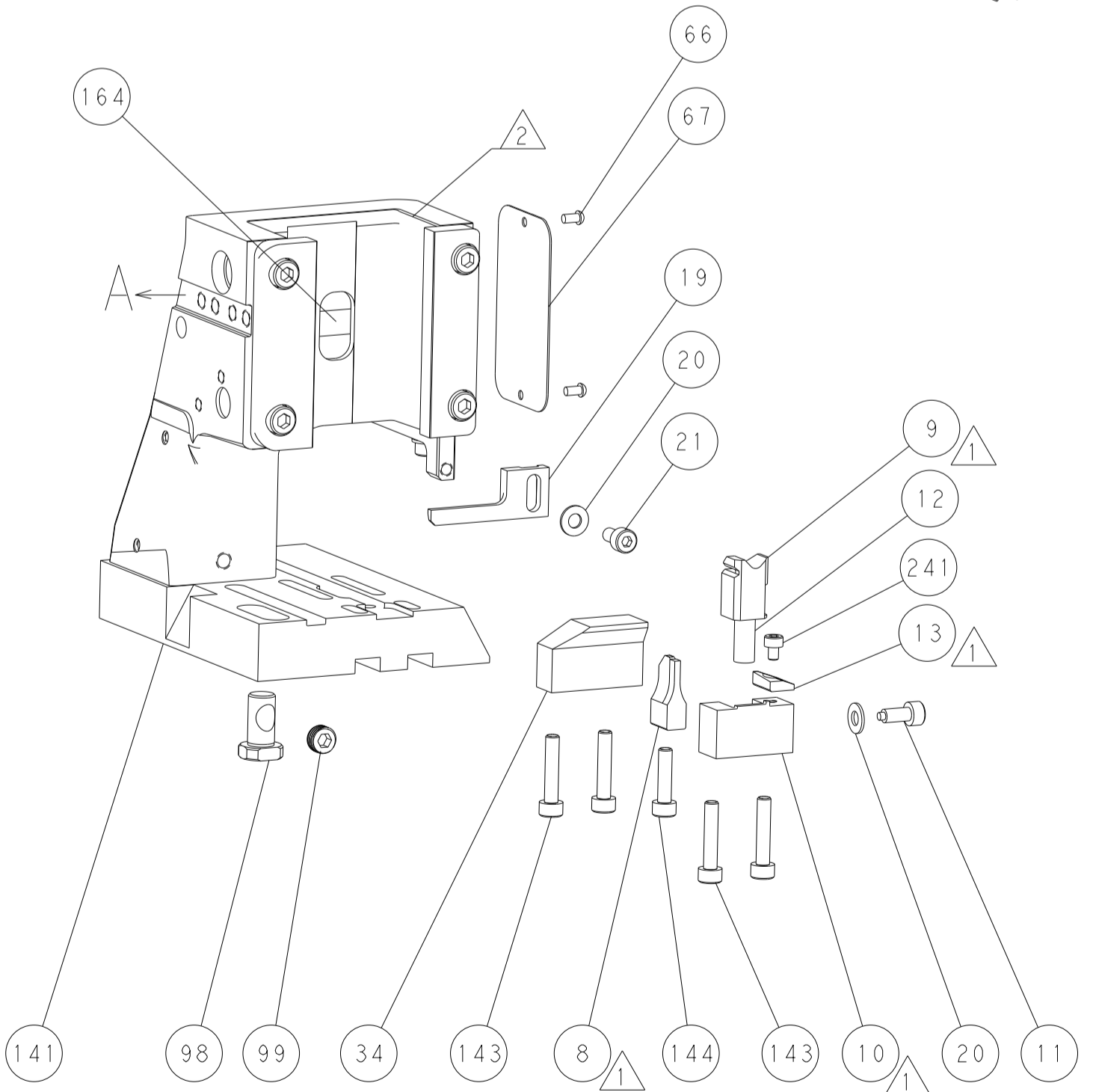
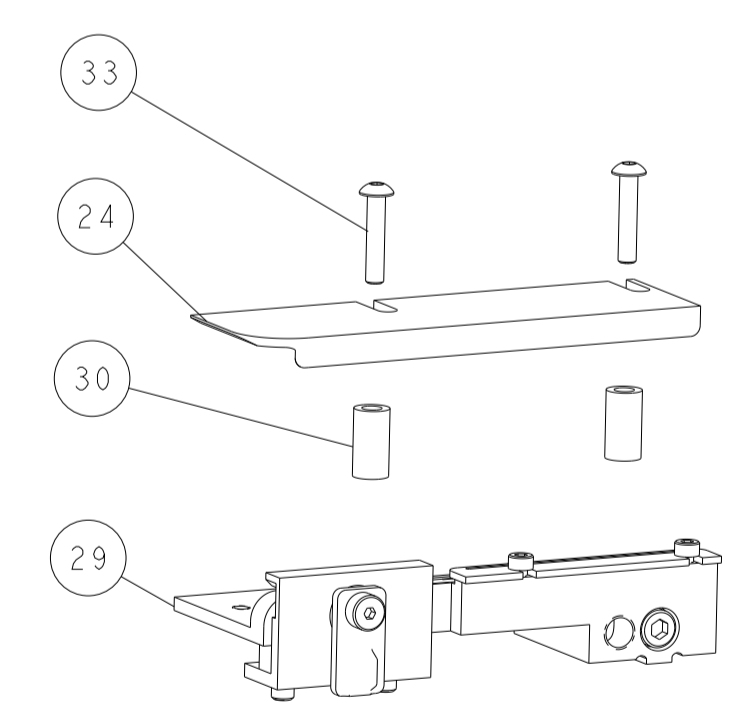
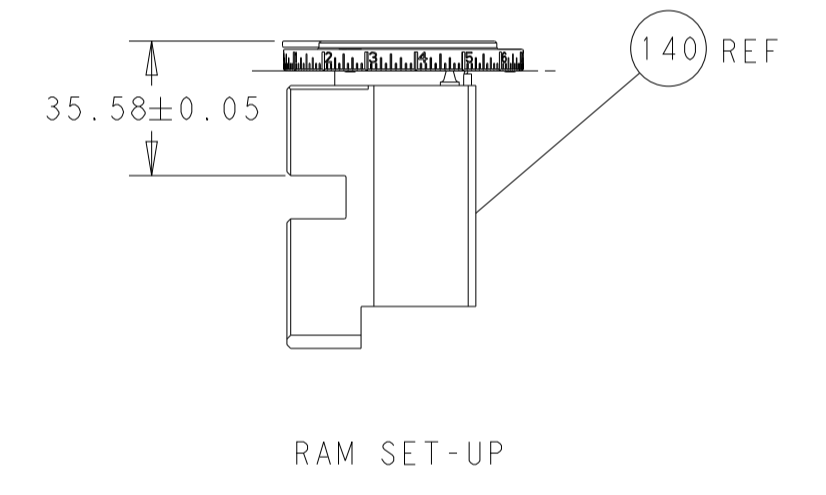
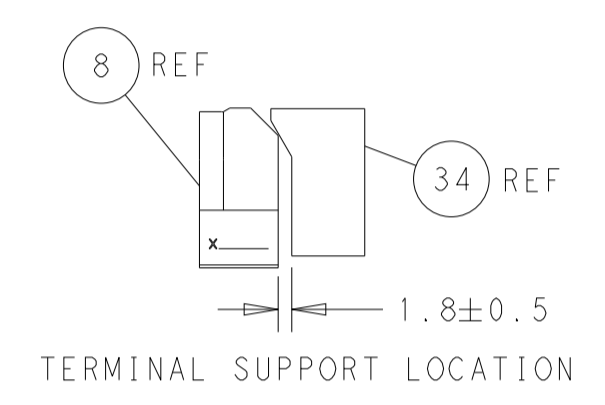
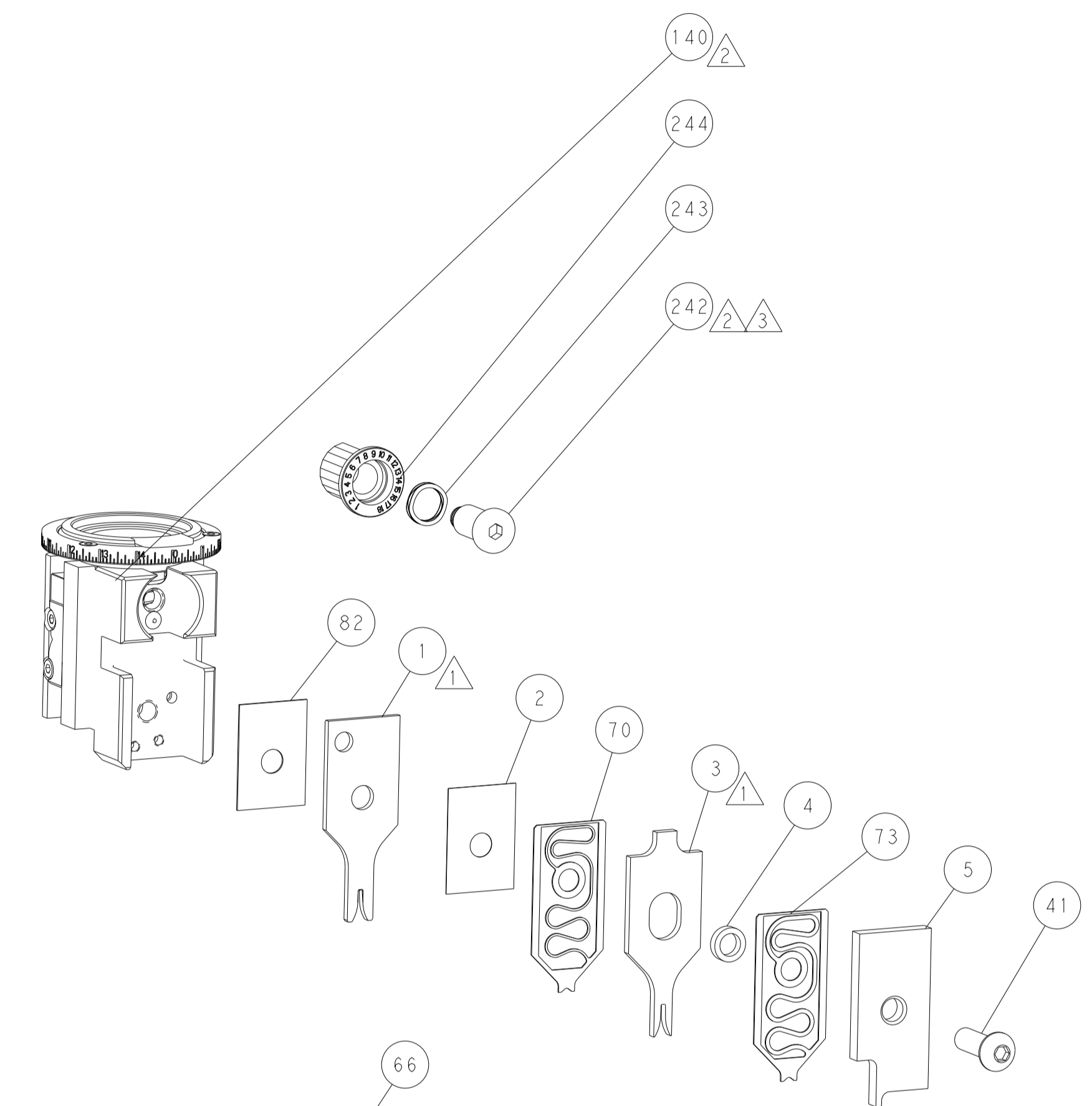
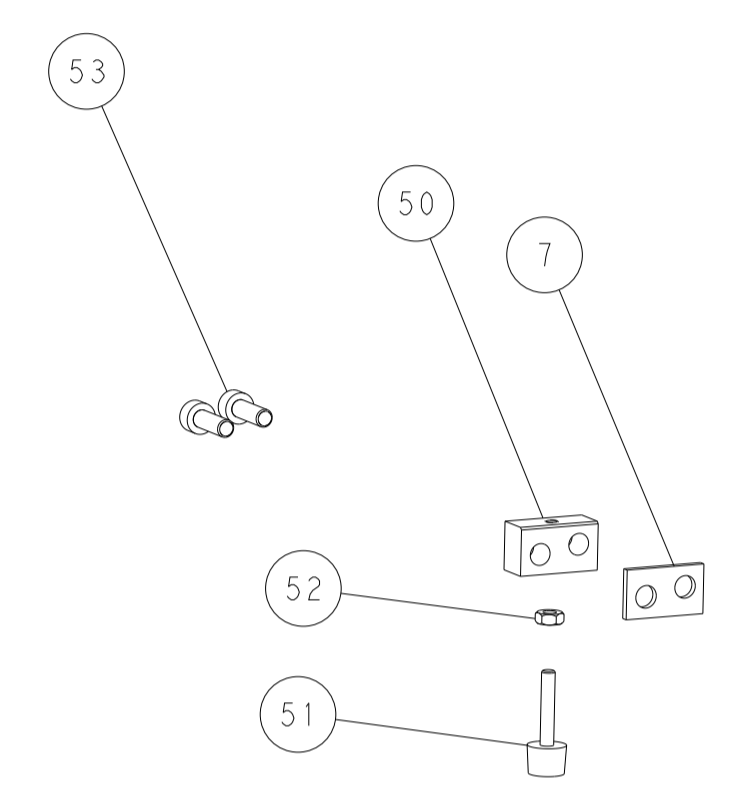
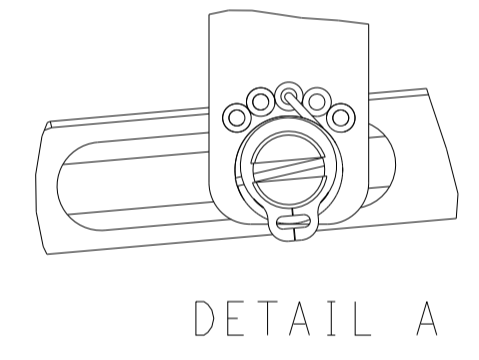
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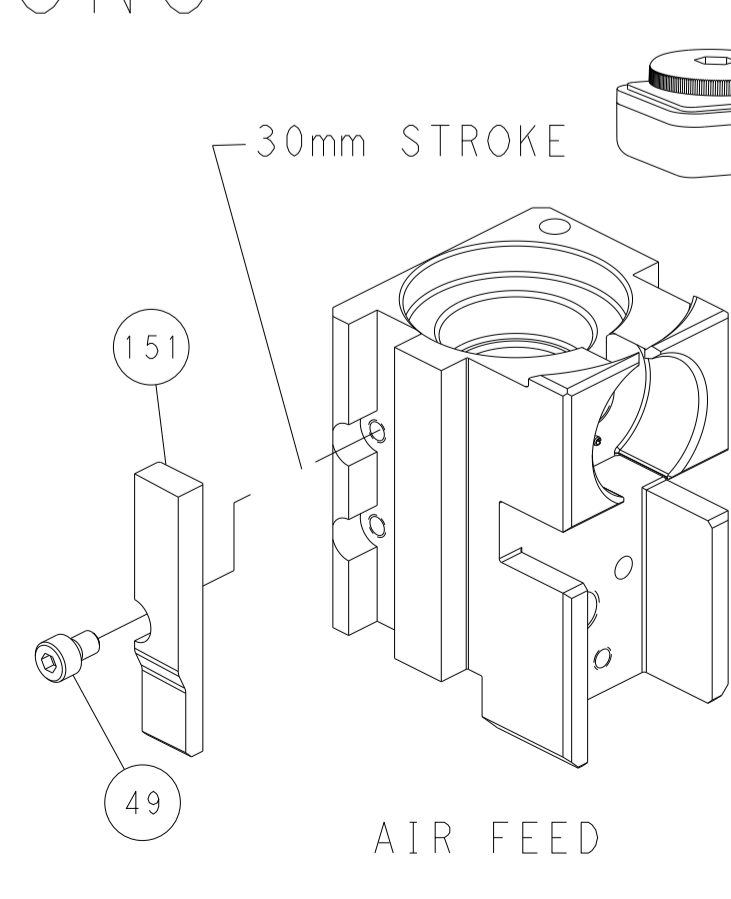
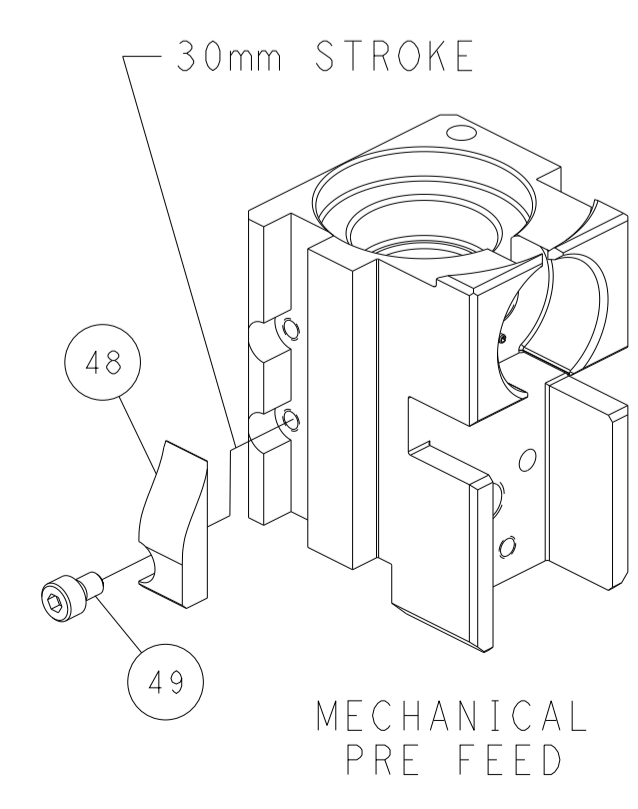
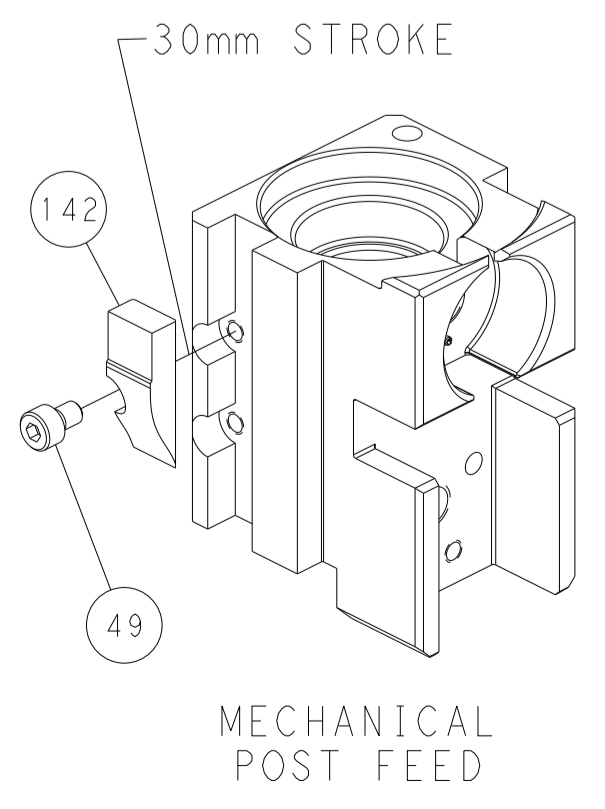
PNEUMATIC



FEED SPRING SETTING POSITION
(SHOWN FROM REAR SIDE)



CAM POSITIONS



PACIFIC VERSION
 Shown on sheets 3 of 4 & 4 of 4
 (Atlantic version shown on sheets 1 of 4 & 2 of 4)

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DIMENSIONS: mm 	TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH	PRODUCT SPEC APPLICATION SPEC WEIGHT SCALE 1:2	SIZE CAGE CODE DRAWING NO A1 00779 C=2151184 SHEET 4 OF 4 REV J